

Work Order ID 57527

April 8, 2010 8:11:29 AM



Page 1

Item ID: D2673-34

Accept



Setup Start



Revision ID:

Stop



Item Name: End Plate

Start Date: 4/08/10 Start Qty: 30.00



Cust Item ID:

Required Date: 4/14/10 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2673	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2673 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

MAT NOT PULLED

6061 .080

1B10-4-13

(57)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B10-4-13

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/04/13

counts
(X57)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
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Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

10-04-13

57

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/15
10-4-14
57

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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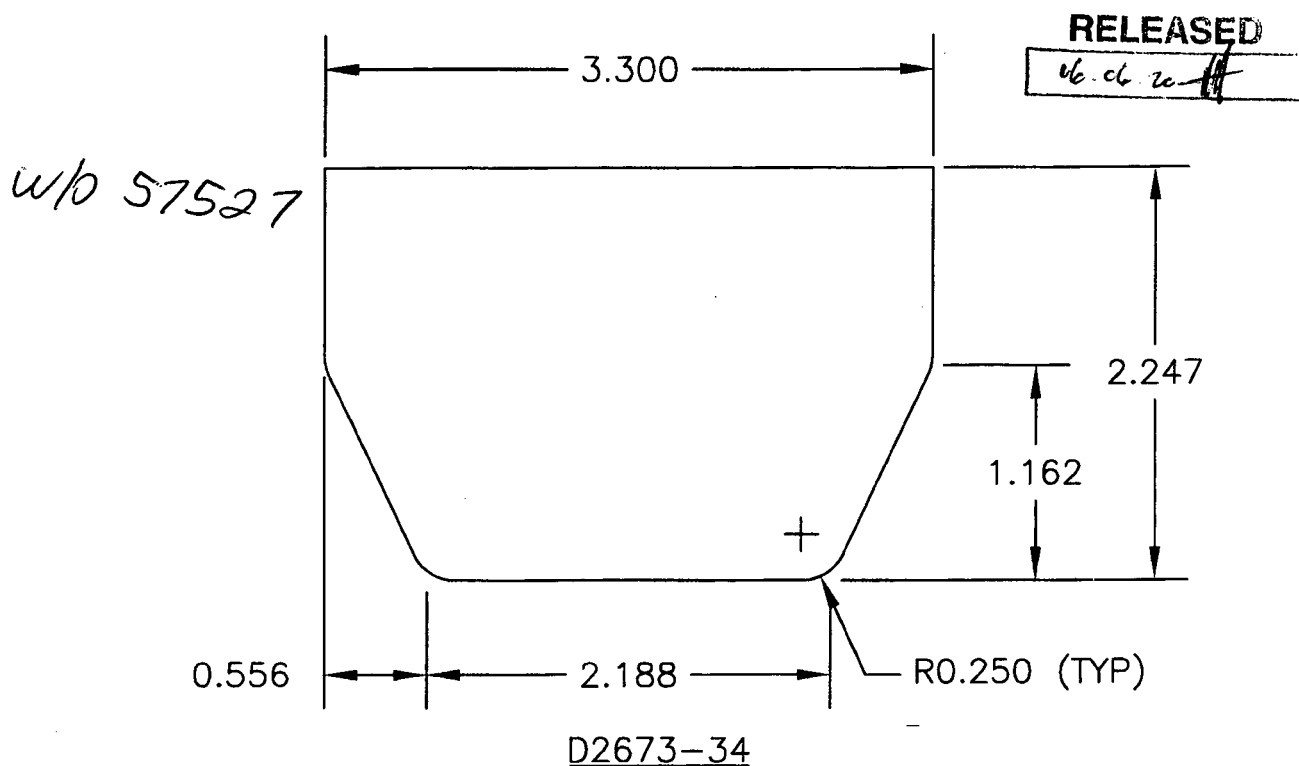


Lean Training Event

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED 	DRAWING NO. D2673	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE END PLATE	SCALE 1:1
A	97.05.06	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

END PLATE FOR D2244 EXTRUSION CUT AT 34°

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Remember....

- Lean is war to WASTE.
- Waste is an activity or output that ***adds cost but does not add value***
- You have to get into a mindset of identifying and eliminating all wastes.

The 7 deadly wastes

- | | |
|--------------------------|------------------------------------|
| 1. Overproduction | 2. Rework |
| 3. Transportation | 4. Inappropriate / over Processing |
| 5. Unnecessary Inventory | 6. Delays / Waiting |
| 7. Unnecessary Motions | |